



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3955-041
Job Sheet 180765



Part No: D3955-041

Job Qty: 5 ea

Part Name: Doubler Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/13/18

Job Tracking No:

Due Date: 7/27/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A IPP RevA: New issue DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea		7/27/18	0.00	0.00	Start Up Waterjet		SC 180717
100	Waterjet	5 pcs		7/27/18	0.03	0.61	Waterjet1		SC 180717
110	QC	5 pcs		7/27/18	0.00	0.00	QC2 Waterjet-3		SC 180717
120	QC	5 pcs		7/27/18	0.00	0.00	QC8-4		38
130	Small Fab	5 pcs		7/27/18	0.00	0.36	Small Fab-5		9-89 DAS 38
140	QC	5 pcs		7/27/18	0.00	0.00	QC5		38
150	HandFinish	5 pcs		7/27/18	0.00	0.41	HandFinish1		SA 18-07-25
160	QC	5 pcs		7/27/18	0.00	0.00	QC7-3		SA 18-7-25
170	Packaging	5 pcs		7/27/18	0.00	0.00	Packaging1-4		38
180	Small Fab	5 pcs		7/27/18	0.00	0.36	Small Fab-5		DAS 38
190	QC	5 pcs		7/27/18	0.00	0.00	QC5		38
200	Packaging	5 pcs		7/27/18	0.00	0.00	Packaging3-2	51062 98	JUL 27 2018
210	QC21-SA	5 Ea		7/27/18	0.00	0.00	QC21		DAS 21 3-89 JUL 27 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	1.7765 sf (.3553 ea)	90-Start up Operation	
MS20427M3-3	Rivet	10 Ea (2 ea)	180-Small Fab	FM136741-4
MS21086L3	Nut Plate	5 Ea (1 ea)	180-Small Fab	FM134754

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.063	2	231	0
180-Small Fab	MS20427M3-3	10	773	0
	MS21086L3	5	9	0

Part Specifications

Specifications could not be found.



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Container No: S092910



Part: D3955-041

Job No: 180765

Serial No/Batch: S092910

Revision:

Inspector:

Exp Date:

Instructions:

Date: 07/17/18

0-88
38
DYE

0-88
38
DYE

DART AEROSPACE LTD		Work Order: 180765
Description: Doubler		Part Number: D3955-1
Inspection Dwg: D3955 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	Ø0.130			15601	
Ø0.201	+0.005/-0.001	Ø0.204			Tap	
0.750	+/-0.010	0.752				
1.000	+/-0.010	1.001				
1.250	+/-0.010	1.253				
1.375	+/-0.010	1.377				
2.38	+/-0.030	2.386				
0.613	+/-0.010	0.615				
1.313	+/-0.010	1.315				
2.063	+/-0.010	2.065				
2.563	+/-0.010	2.565				
3.063	+/-0.010	3.065				
4.813	+/-0.010	4.815				
6.313	+/-0.010	6.315				
7.313	+/-0.010	7.315				
7.813	+/-0.010	7.815				
8.199	+/-0.010	8.200				
8.449	+/-0.010	8.450				
9.188	+/-0.010	9.190				
9.438	+/-0.010	9.440				
10.413	+/-0.010	10.415				
10.75	+/-0.030	10.75				
0.063	+/-0.010	0.063				

Measured by: SL	Audited by: 38	Prototype Approval:	N/A
Date: 16/07/17	Date: JUL 19 2018	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue P/O D3955-041	KJ	